

# Work Order ID 106477

Tuesday, September 03, 2013 1:03:06 PM

**\*106477\***

Page 1

Item ID: D4099-1

Revision ID:

Item Name: Bracket

Start Date: 9/3/2013 Start Qty: 8.00

Required Date: 9/5/2013 Req'd Qty: 8.00

Reference:

Approvals:

Process Plan: *mf*

QC:

Date: *13-9-03*

Date:

Tooling:

SPC (Y/N):

**\*N900040100\***

Cust Item ID:

Customer:

Setup Start

**\*NS1\***

Stop

**\*NS2\***

Run Start

**\*NR1\***

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4099	A								
100		0.00							
<b>*100*</b>	FLOW WATER JET			13		0			<i>Ac</i> <i>13.09.04</i>
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg Dwg Rev: <u>A</u> Prog Rev: <u>A</u> 2-Debur if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00		13		0			<i>Ac</i> <i>13.09.04</i>
<b>*110*</b>									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
<b>*120*</b>									
QC	Memo	0.00		13					
Quality Control									

**D4099-1**  
**B106477**

*\*8\**  
*\*13\**

DAS  
27  
9-89

*13 9 3*

*13*



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Item ID: D4099-1

Revision ID:

Item Name: Bracket

Start Date: 9/3/2013 Start Qty: 8.00

Required Date: 9/5/2013 Req'd Qty: 8.00

Reference:

Accept

**\*N900040100\***Setup Start **\*NS1\***Stop **\*NS2\***

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursTool ID Tool # Plan  
Code Accept Reject Reject Insp.  
Qty Qty Number Stamp

130

0.00

**\*130\***

Small Fab

Memo

0.00

Small Fab

C'sink holes as per dwg

13X

140

0.00

**\*140\***

Brake NC

Bend as per dwg

NC BRAKE

Memo

0.00

Brake NC

13

150

0.00

**\*150\***

QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

DAS  
16  
9-89

13/09/13

21

11

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Page 3

Item ID: D4099-1

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Bracket

Start Date: 9/3/2013 Start Qty: 8.00

**\*8\***

Cust Item ID:

Required Date: 9/5/2013 Req'd Qty: 8.00

**\*8\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.  
Code Qty Qty Number Stamp

160

Chemical Conversion Coat per QSI005 4.1

0.00

**\*160\***

HandFinish

Memo

0.00

Hand Finishing

13 13-9-5

170

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

**\*170\***

Powdercoat

Memo

0.00

Powder Coating

Start Time: 12:45  
Oven Temperature: 320°F  
Finish Time: 1:15

180

QC3- Inspect Part Finish

0.00

**\*180\***

QC

Memo

0.00

Quality Control

1121279

13X 13/09/05

130 13-9-5





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Page 4

Item ID: D4099-1

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Bracket

Start Date: 9/3/2013 Start Qty: 8.00

**\*8\***

Cust Item ID:

Required Date: 9/5/2013 Req'd Qty: 8.00

**\*8\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursTool ID Tool # Plan Accept Reject Reject Insp.  
Code Qty Qty Number Stamp

290

Identify as per dwg & Stock Location: ST247A

0.00

**\*290\***

Packaging

Memo

0.00

Packaging

2X (GA)

13X (28) 13-09-5

300

QC21 - Final Inspection - Work Order Release

0.00

**\*300\***

QC

Memo

0.00

Quality Control

13/9/9  
MF  
13-9-6





# Picklist Print

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Page 1

Work Order ID: 106477

Parent Item: D4099-1

Parent Item Name: Bracket

Start Date: 9/3/2013

Required Date: 9/5/2013

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A as per ECN10-573 DD 10.05.18 ver:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.080  
6061-T6 .080 Sheet

Purchased

No

100

sf

655.7500

0.2627

~~2.2122105~~

*1e 13.09.04*

## Location

## Loc Qty

## Loc Code

MAT021

655.75

125812

33.75

m126309

363.5

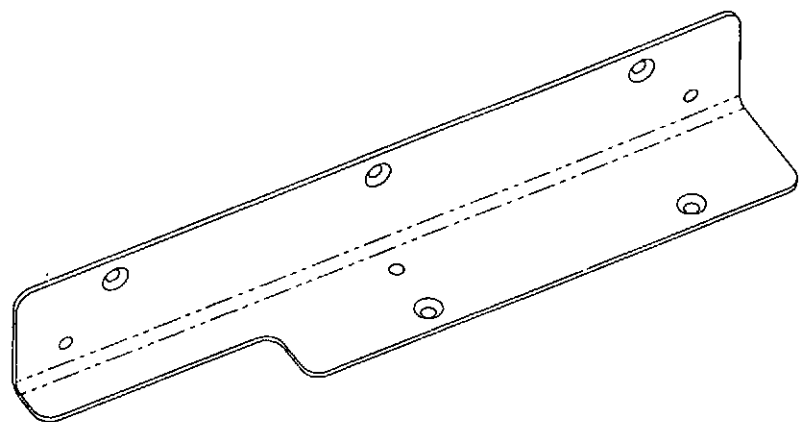
m126350

258.5

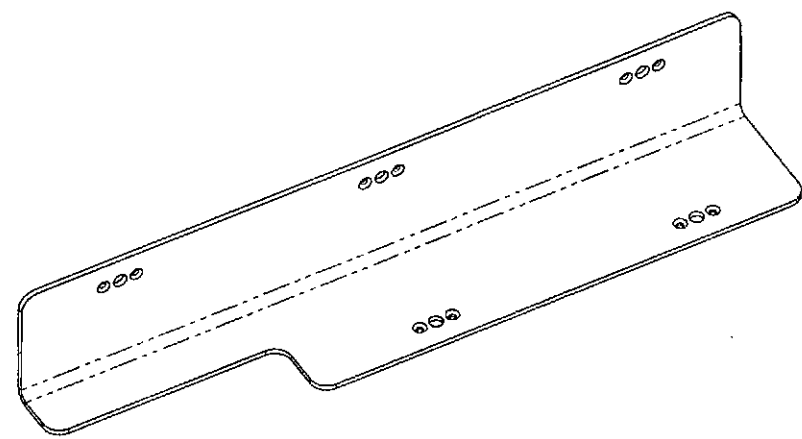
126350 → 3.6

*Das  
27*

2



D4099-1 BRACKET

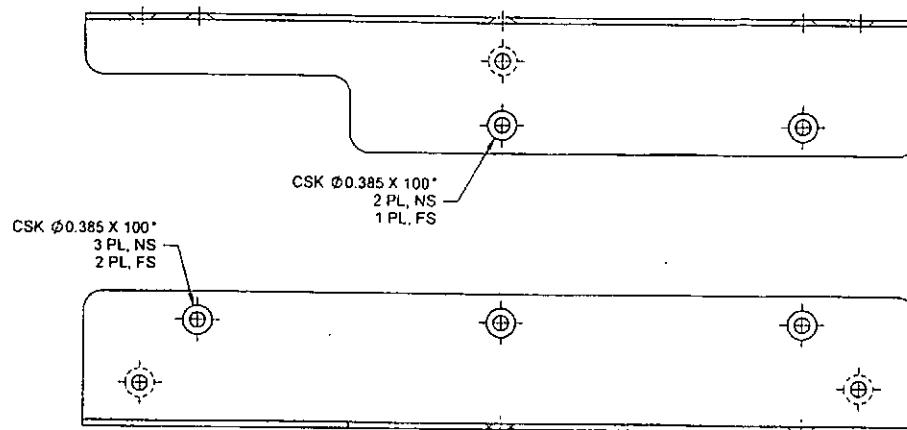


D4099-3 BRACKET

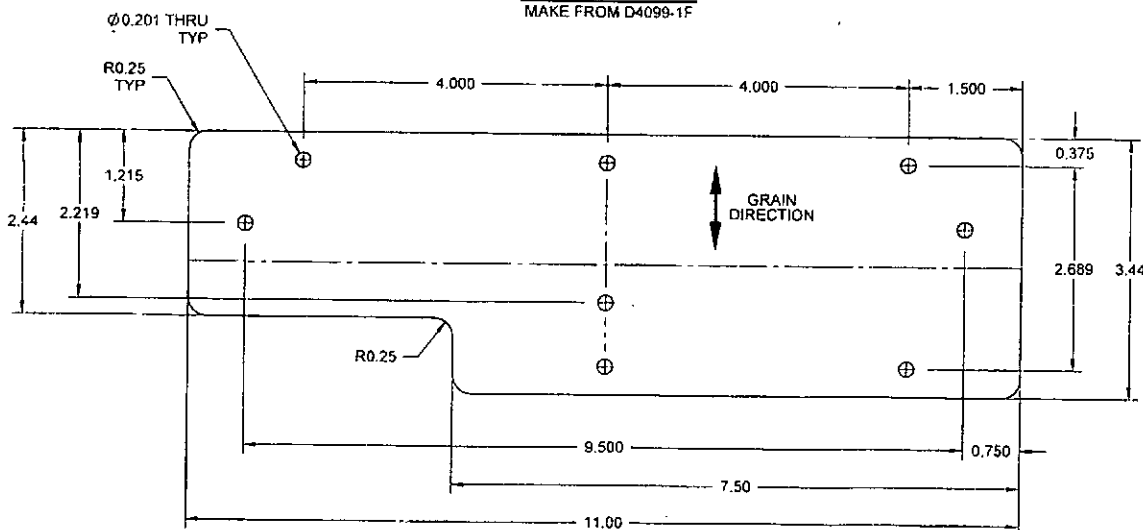
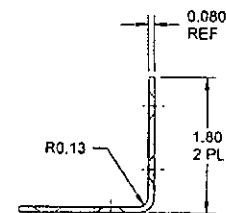
**RELEASED**  
2010-05-17

A		NEW ISSUE		DESCRIPTION		MB	10.05.05
REV.						BY	DATE
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DRAWN				HAWKESBURY, ONTARIO, CANADA		SHEET 1 OF 3	
CHECKED				DRAWING NO.			
MFG. APPR.				D4099			
APPROVED				TITLE		SCALE	
DE APPR.				BRACKET		NTS	
DATE	10.05.05			<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS NOT TO BE RELEASED OR DISCLOSED TO ANY OTHER PERSON OR ENTITY WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</small>			





**D4099-1 BRACKET**  
MAKE FROM D4099-1F



**D4099-1F FLAT PATTERN**

**RELEASED**  
2010-05-17

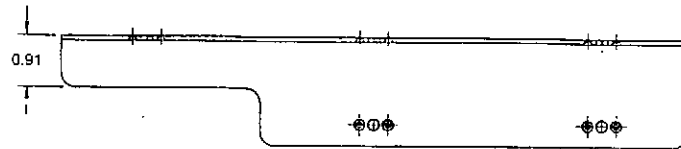
**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR  
ASTM B209  
REF. DART SPEC. M6061T6S.080
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANOTEX (4.3.5.5) PER DART  
QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.26 lbs

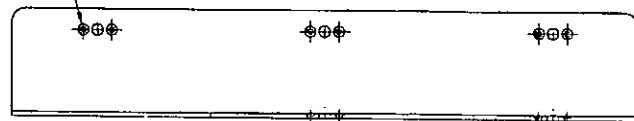
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DRAWN	1A	HAWKESBURY, ONTARIO, CANADA	
CHECKED	1A	DRAWING NO.	REV. A
MFG. APPR.	1A	D4099	SHEET 2 OF 3
APPROVED	1A	TITLE	SCALE
DE APPR.	1A	BRACKET	NTS
DATE	10.05.05	COPYRIGHT © 2013 BY DART AEROSPACE LTD	



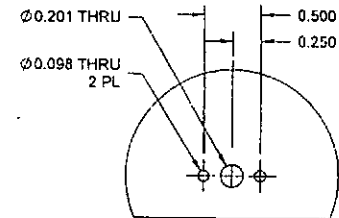
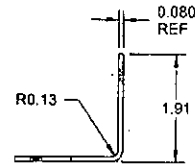
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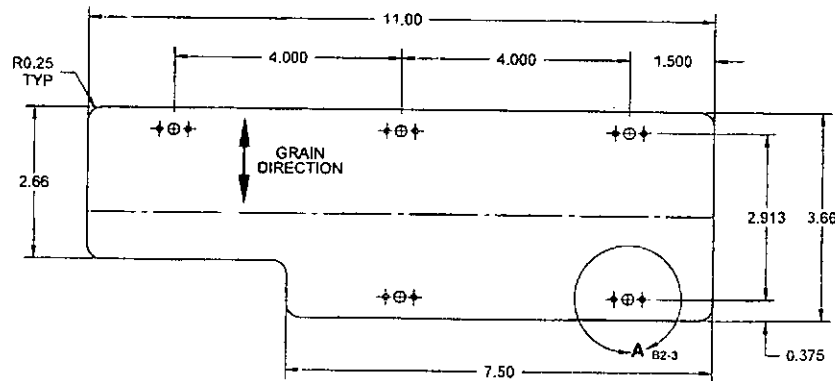
CSK  $\phi 0.188 \times 100^\circ$   
TYP



**D4099-3 BRACKET**  
MAKE FROM D4099-3F



**DETAIL A**  
SCALE 2X, 5 PL A5-3



**D4099-3F FLAT PATTERN**

**RELEASED**  
2010-05-17

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR  
ASTM B209  
REF: DART SPEC. M6061T6S.080
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.28 lbs

DESIGN	16	<b>DART AEROSPACE LTD</b>	
DRAWN	B	HAWKESBURY, ONTARIO, CANADA	
CHECKED	18	DRAWING NO.	REV. A
MFG. APPR.	18	D4099	SHEET 3 OF 3
APPROVED	18	TITLE	SCALE
DE APPR.	18	BRACKET	NTS
DATE	10.05.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD	

8 7 6 5 4 3 2 1







